

Date: Friday, 17/10/2008 12:43:52 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOOR DOUBLER		
Job Number	: 42722		Part Number	: D3594043		
Estimate Number	: 12681		Drawing Number	: D3594 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 17/10/2008		Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 05/11/2008		
Previous Run	: 40476		Qty:	8		
Written By	:		Um:	Each		
Checked & Approved By	: JUL 08 10-17					
Comment	: Est Rev :A New Issue 07-01-22 EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
		Comment: Qty.: 0.5355 sf(s)/Unit Total : 4.2840 sf(s) 6061-T6 .080 Sheet Batch: 108433 HB 8-10-20	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3594 Dwg Rev: B HB 8-10-20 Prog Rev: B	(8)
		2-Deburr if necessary HB 8-10-20	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	HB 8-10-20
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	S 08/10/20 (8)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 C'SINK AS PER DWG D3594	EBS/10/21 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/10/2008 12:43:52 PM
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Drawing Name: DOOR DOUBLER

Job Number: 42722

Part Number: D3594043

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/21 (X8)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

(U)

08.10.22

(X8)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

E 08/10/23 (8)

9.0 MS210695

Anchor nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Anchor nuts

BATCH: M107938

E 08/10/23

10.0 MS20426AD44

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Rivet

BATCH: M1021

E 08/10/23

11.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plates As per Dwg D3594

E 08/10/23 (8)

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/23 (X8)

13.0 PACKAGING 1

PACKAGING RESOURCE #1



(8x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 240

8/10/23

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/10/2008 12:43:52 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 42722

Part Number: D3594043

Job Number:



Seq. #: Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/27 off

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	42722
Description: Floor Doubler, LH	Part Number:	D3594-3
Inspection Dwg: D3594	Rev: B	Page 1 of 1

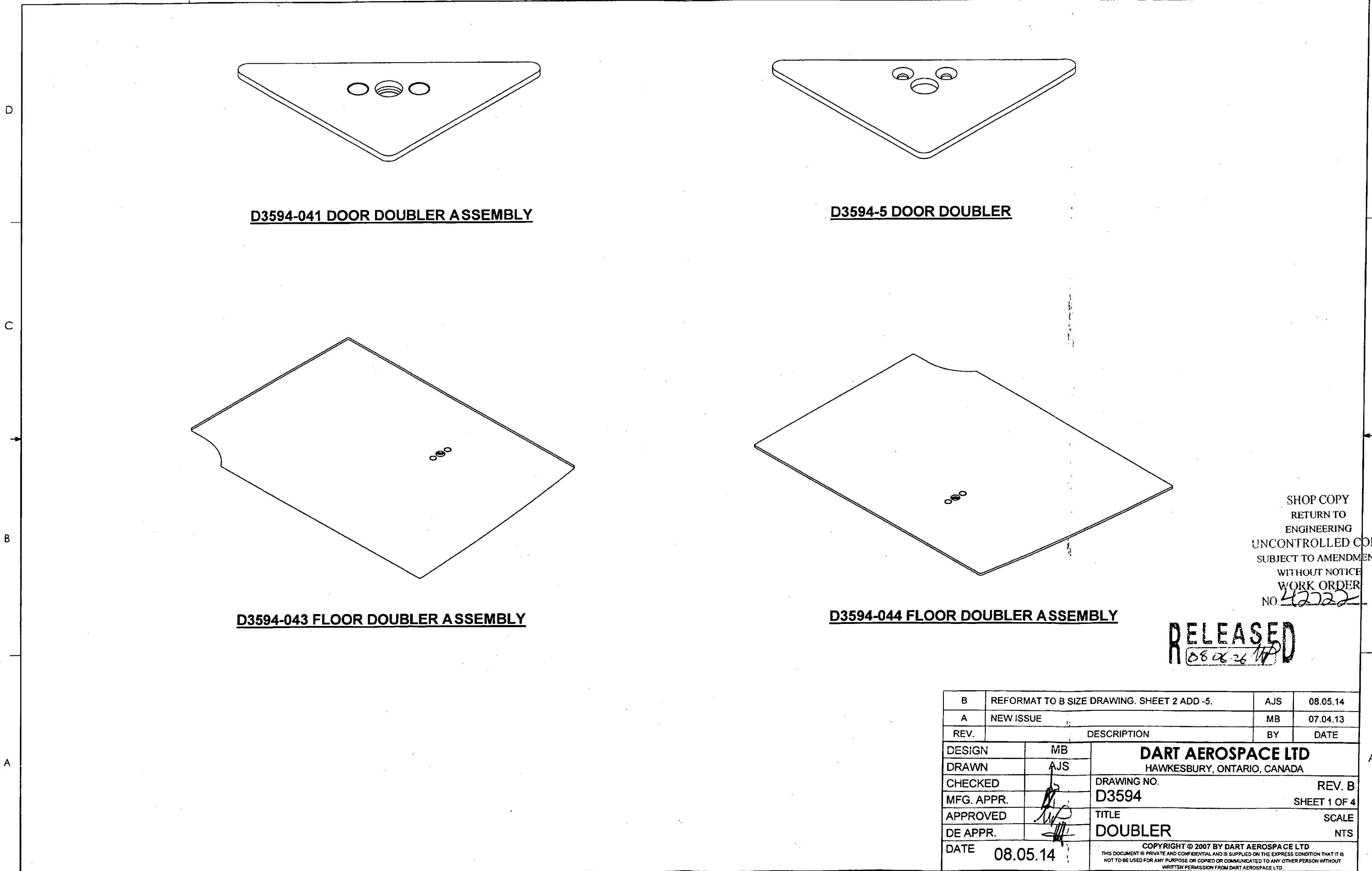
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	1B	Audited by:	S	Prototype Approval:	N/A
Date:	8-10-20	Date:	08/10/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue P/O D3594-043	KJ/JLM	
B	08.09.04	Dwg Rev updated	KJ/DD	

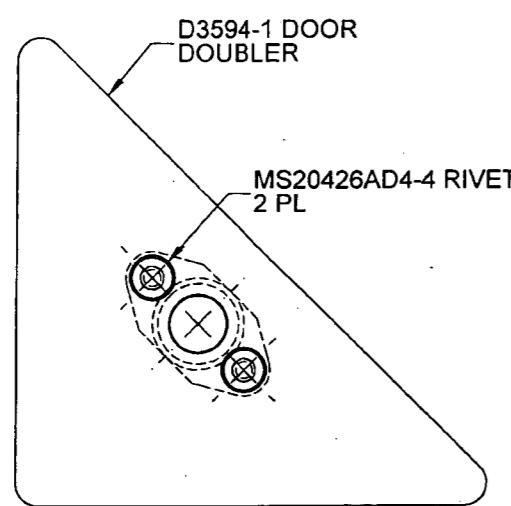
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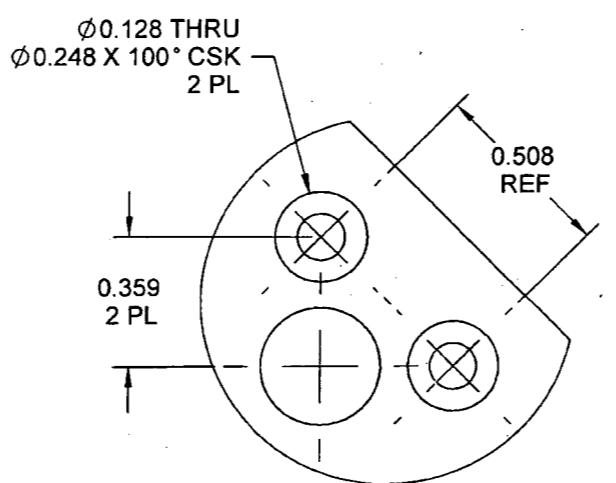
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8 7 6 5 4 3 2 1

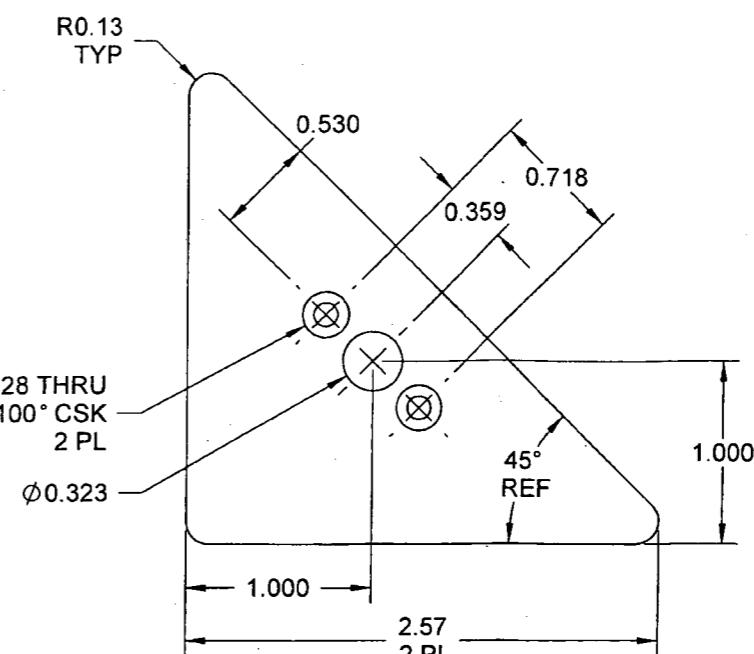
QTY. -041	PART NUMBER	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069L5	ANCHOR NUT
2	MS20426AD4-4	RIVET, CSK



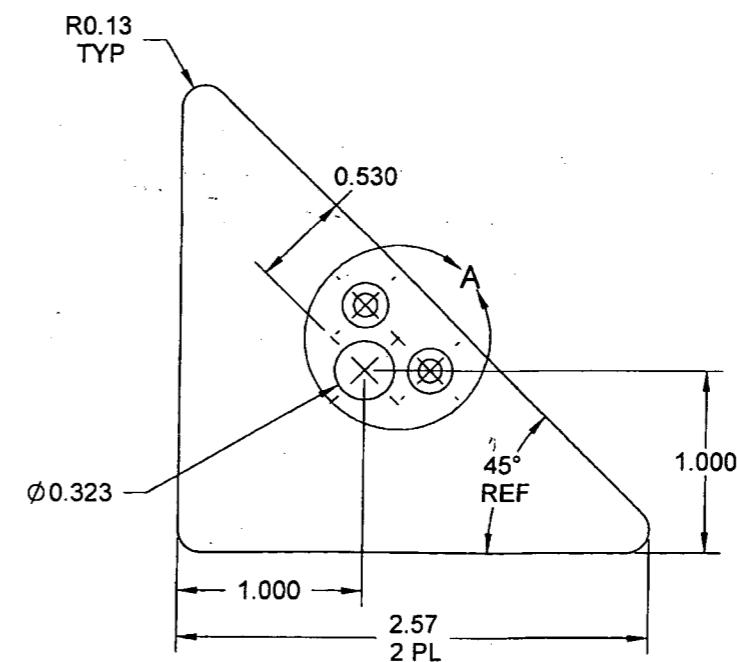
4) D3594-041 DOOR DOUBLER ASSEMBLY



DETAIL A
SCALE 2X



D3594-1 DOOR DOUBLER



5) D3594-5 DOOR DOUBLER △

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 402722

RELEASED
08.06.26/14

NOTES:

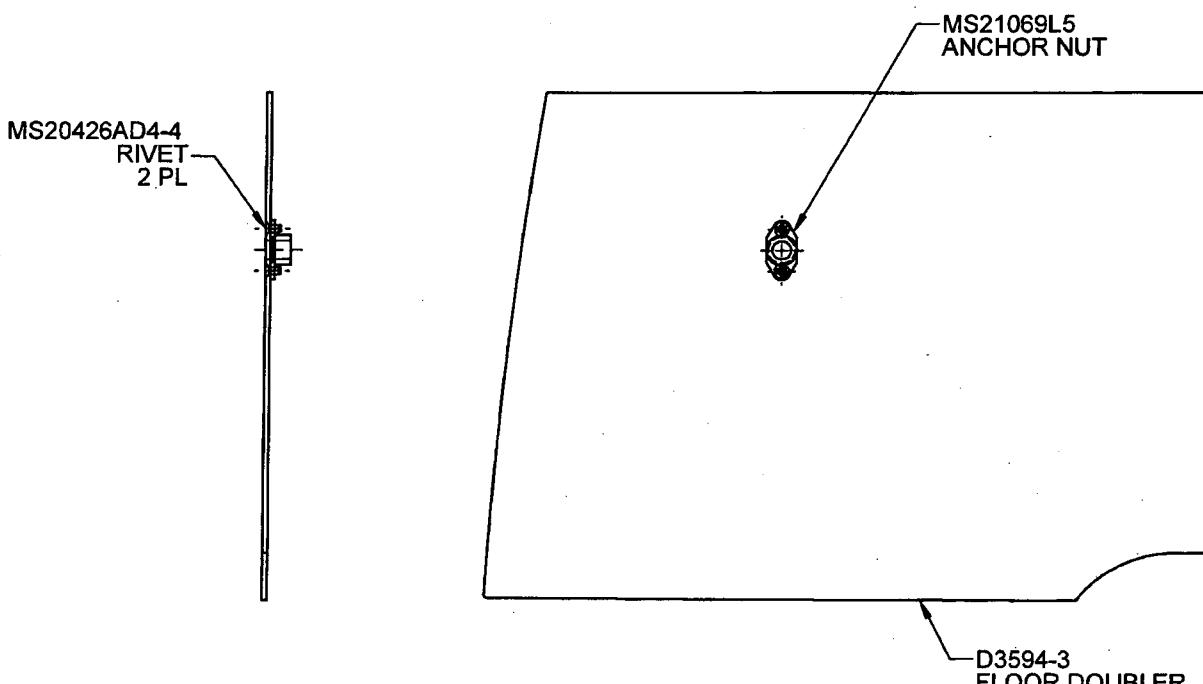
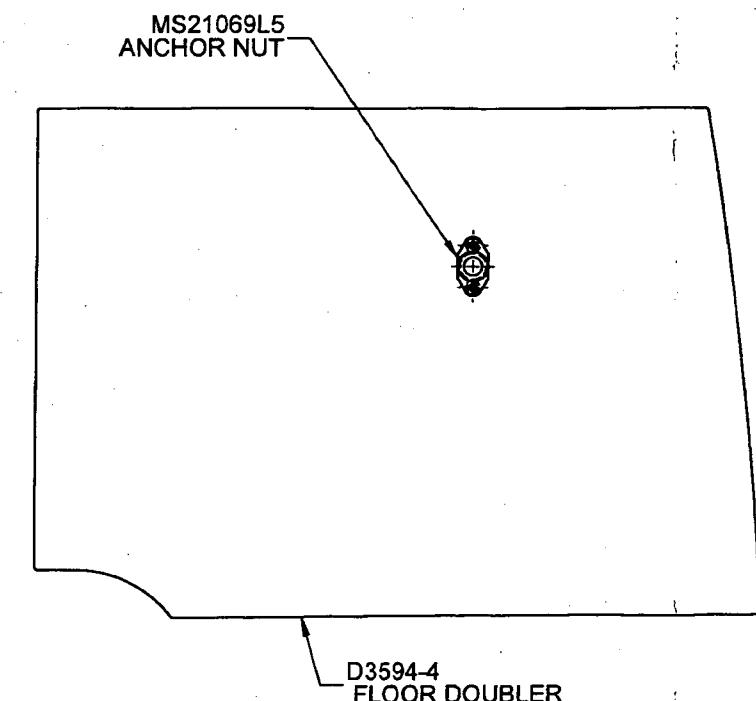
- 1) MATERIAL: -1 & -5
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) IDENTIFY WITH DART P/N "D3594-5" USING FINE POINT PERMANENT INK MARKER
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -041: 0.04 lbs
-5: 0.03 lbs

DESIGN	MB.	DART AEROSPACE LTD
DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		D3594
APPROVED		REV. B
DE APPR.		SHEET 2 OF 4
DATE	08.05.14	TITLE DOUBLER
		SCALE NTS

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8 7 6 5 4 3 2 1

QTY. -043	QTY. -044	PART NUMBER	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	X	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069L5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET, CSK

D3594-043 FLOOR DOUBLER ASSEMBLYD3594-044 FLOOR DOUBLER ASSEMBLY

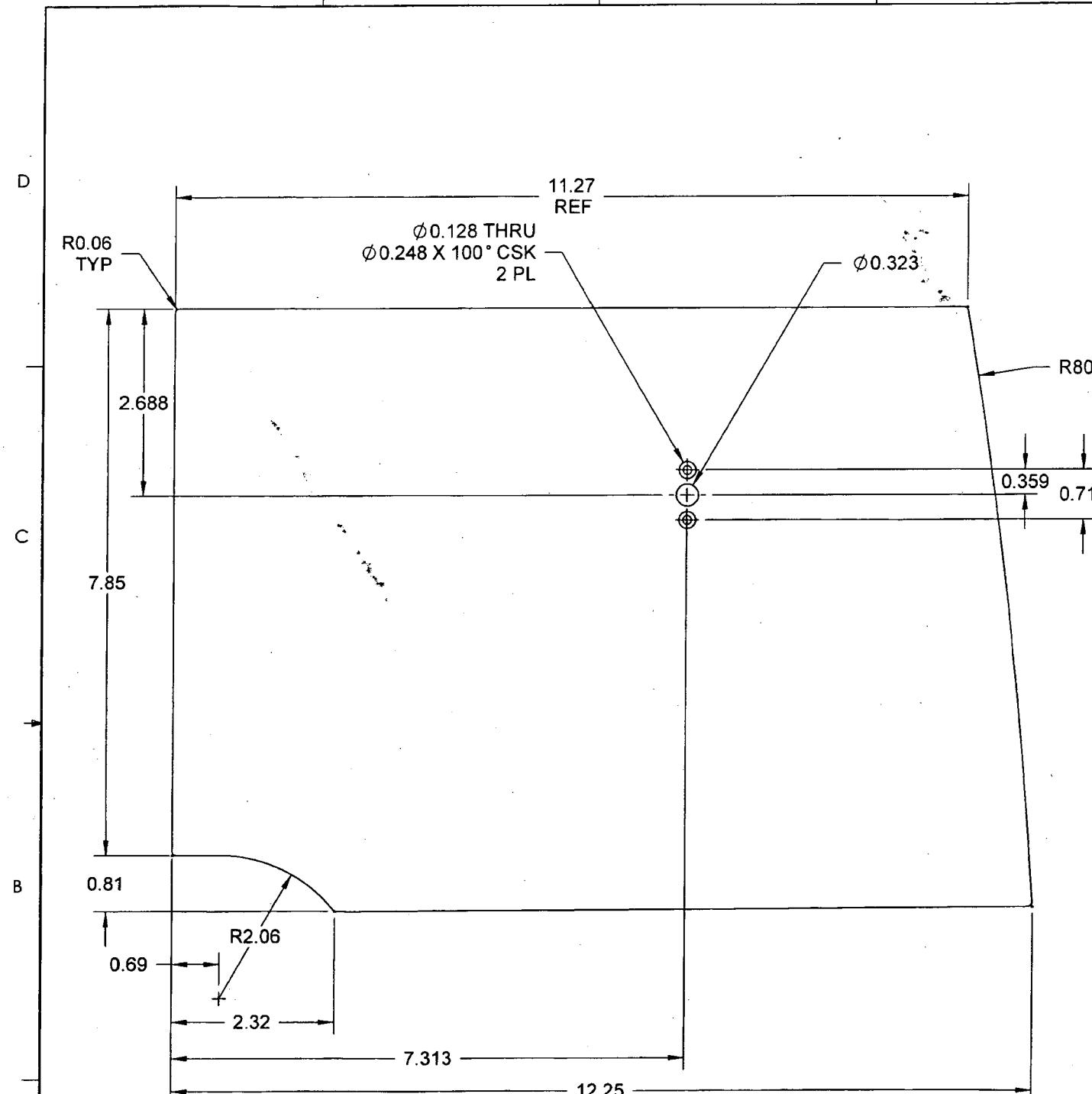
NOTES:

- 1) MATERIAL: -3 & -4
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK,
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) WEIGHT -043 & -044: 0.80 lbs

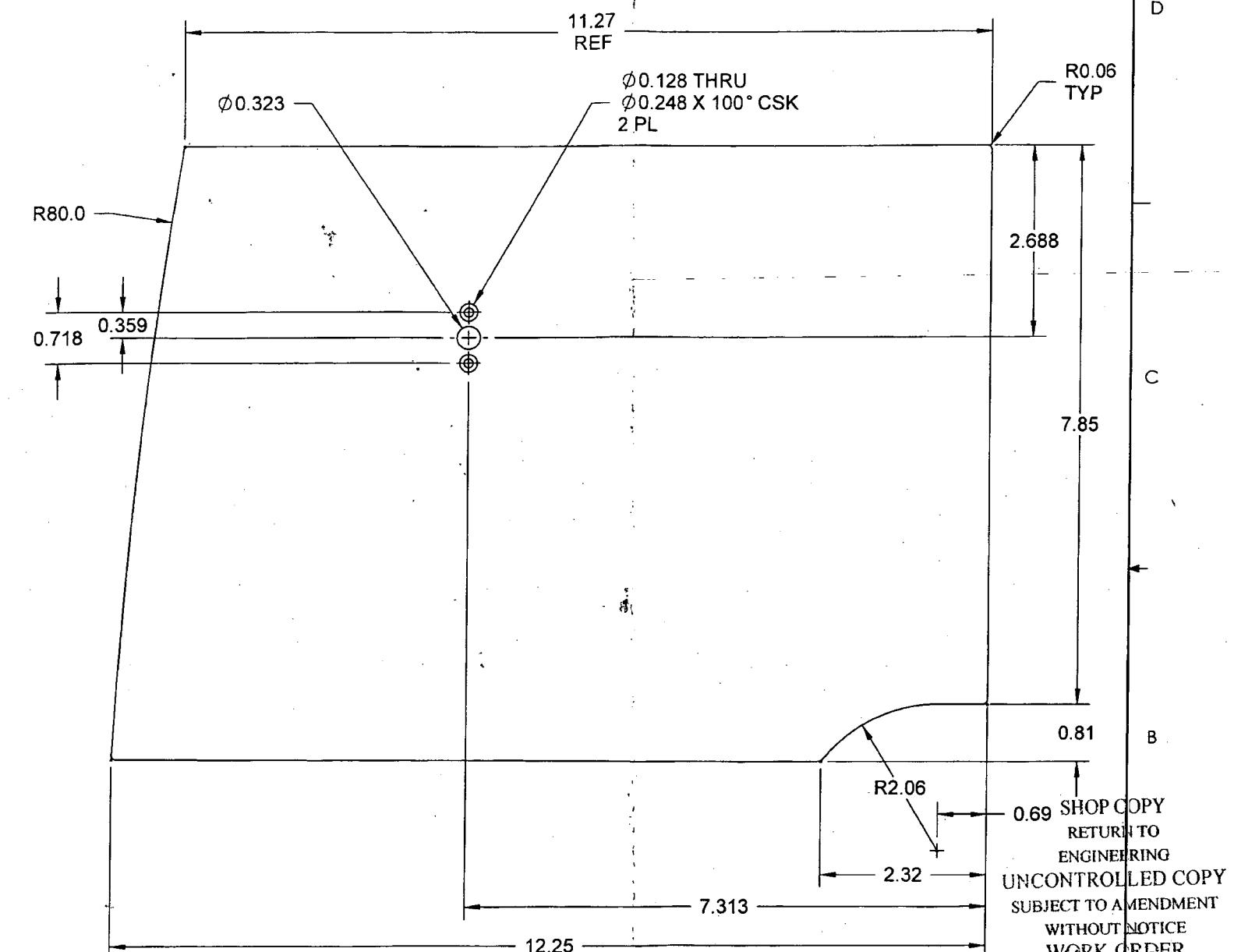
DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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RELEASED
08.06.2014

8 7 6 5 4 3 2 1



D3594-3 FLOOR DOUBLER



D3594-4 FLOOR DOUBLER

RELEASED N
08-08-26 W

- NO 42923

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3594	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		DOOR DOUBLER ASSEMBLY NTS	
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